

5/16

DART AEROSPACE LTD	Work Order:	22406
Description: Strut Assembly	Part Number:	D3180-041
Dwg: D3180 Rev. A	Qty:	1
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty																																				
1	DC	Issue Traveller	JA	05.02.14	1																																				
2	MC GA	Punch 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall to length as per Dwg D3180 using DT8313 (M304TR0.750W0.049) Ensure rotate and punch one end only as per view B-B as per Dwg. D3180 Batch: M17060	SB	05/03/21	1																																				
3	GA	Drill Ø0.203" as per Dwg D3180	SB	05/03/22	1																																				
4	GA	Bend one side only as per Dwg D3180 Identify as D3180-1	SB	05/03/22	1																																				
5	GA	Deburr edges	SB	05/03/22	1																																				
6	QC5	Inspect work to Step 5	SB	05.03.22	1																																				
7	FP	Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	ML	05.03.30	1																																				
8	QC3	Inspect Powder Coat	J	05-04-18	1																																				
9	GA	Assemble as per Dwg D3180. D3180-1 on BOM as material listed in Step 2. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2022-101</td> <td>Spacer</td> <td>B21505</td> </tr> <tr> <td>1</td> <td>D2690-6</td> <td>Lanyard</td> <td>B19300</td> </tr> <tr> <td>1</td> <td>D3180-1</td> <td>Strut</td> <td>B22406</td> </tr> <tr> <td>1</td> <td>A1449</td> <td>Grommet</td> <td>M1487</td> </tr> <tr> <td>3</td> <td>AN960JD10</td> <td>Washer</td> <td>M16895</td> </tr> <tr> <td>1</td> <td>BLRS-001</td> <td>Pip Pin</td> <td>M15608</td> </tr> <tr> <td>1</td> <td>MS21042L3</td> <td>Nut (or -3)</td> <td>M15539</td> </tr> <tr> <td>1</td> <td>MS27039-1-10</td> <td>Screw</td> <td>M13654</td> </tr> </tbody> </table> Identify as D3180-041	Qty	Part Number	Description	Batch	2	D2022-101	Spacer	B21505	1	D2690-6	Lanyard	B19300	1	D3180-1	Strut	B22406	1	A1449	Grommet	M1487	3	AN960JD10	Washer	M16895	1	BLRS-001	Pip Pin	M15608	1	MS21042L3	Nut (or -3)	M15539	1	MS27039-1-10	Screw	M13654	J	05.04.18	1
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10	QC5	Inspect work to Step 9	B	05.04.18	1																																				
11	ST	Identify and Stock	CL	05/04/20	1																																				
12	AC	Cost / part 73.68	SAC	05.04.21	1																																				
13	DC	Close W/O 73.68 Inspect Level 21	JA	05.04.22	1																																				

Rev	Date	Change	Revised By	Approved
A	03.01.27	New issue	KJ/RF	RF

RELEASED
03.01.27 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

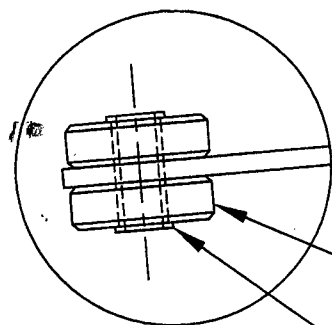
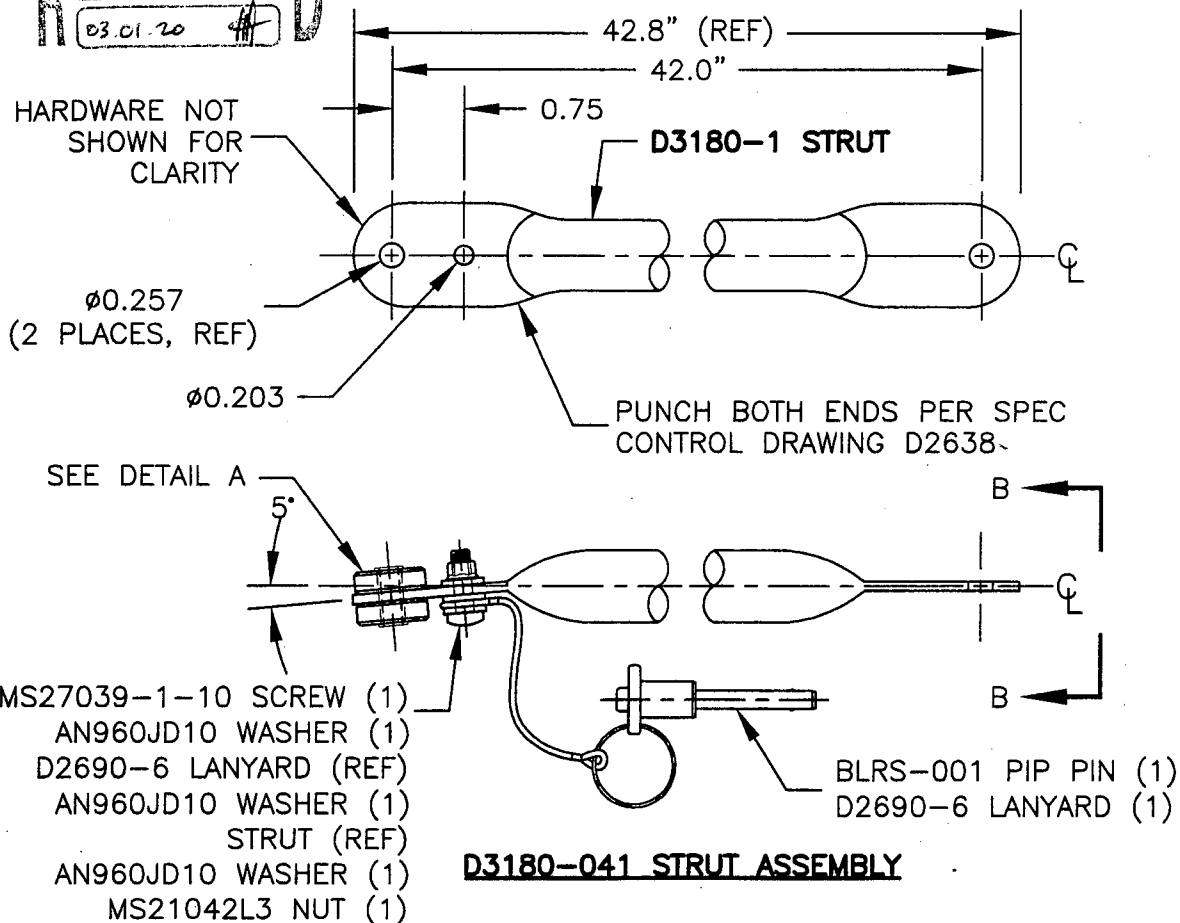
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

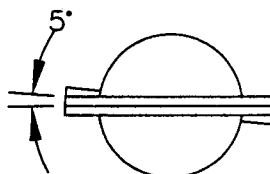


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3180	REV. A SHEET 1 OF 1
DATE 03.01.06		TITLE STRUT ASSEMBLY	SCALE 1:1
A	03.01.06	NEW ISSUE	

RELEASED
03.01.20



DETAIL A
SCALE 1:1



VIEW B-B
SCALE 1:1

D2022-101 SPACER
(2 PLACES)

SWAGE D2022-101 SPACERS ONTO
D3180-1 STRUT USING A1449 GROMMET
(1 PLACE)

D3180-1 STRUT

- 1) MATERIAL: AISI 304/316/318 SS TUBE, Ø0.75 X 0.049 WALL
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE

WORK ORDER
NO. 22406

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 14, 2005
07:34 am

Work Order No : 0022406
Project Name : D3180-041
Project For : WK516
Work Order Type : Main
Main WO Number :
House Part Number : D3180-041
Description : Strut Assembly
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 02-11-05
Est Finish Date : 04-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00